

Date: Friday, 2/23/2007 1:58:12 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW ASSEMBLY
Job Number	: 30948		
Estimate Number	: 12128		
P.O. Number	: N/A	Part Number	: D412729011
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: DSK 092 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 30947	Material	: N/A
Written By	:	Due Date	: 3/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>JO 07.02.26</u>		
Comment	: Est Rev: A 05.01.12 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-729-011 CHG003

KS 07.03.05 (1)

2.0	30948A	GHW MEDIUM BELL
-----	--------	-----------------



Comment: Sub-Component GHW MEDIUM BELL
 D412-729-041 B B30948 A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

PC 7/3/28 (1)

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT 100% KITS FOR COMPLETENESS

EP 04/03/28 (1)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Identify and pack for shipping as per PPP D412-729-011
 Location: D
 PPP Rev: D

PC 7/3/28 (1)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

D 07/03/29 (1)

Job Completion



U 07.03.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

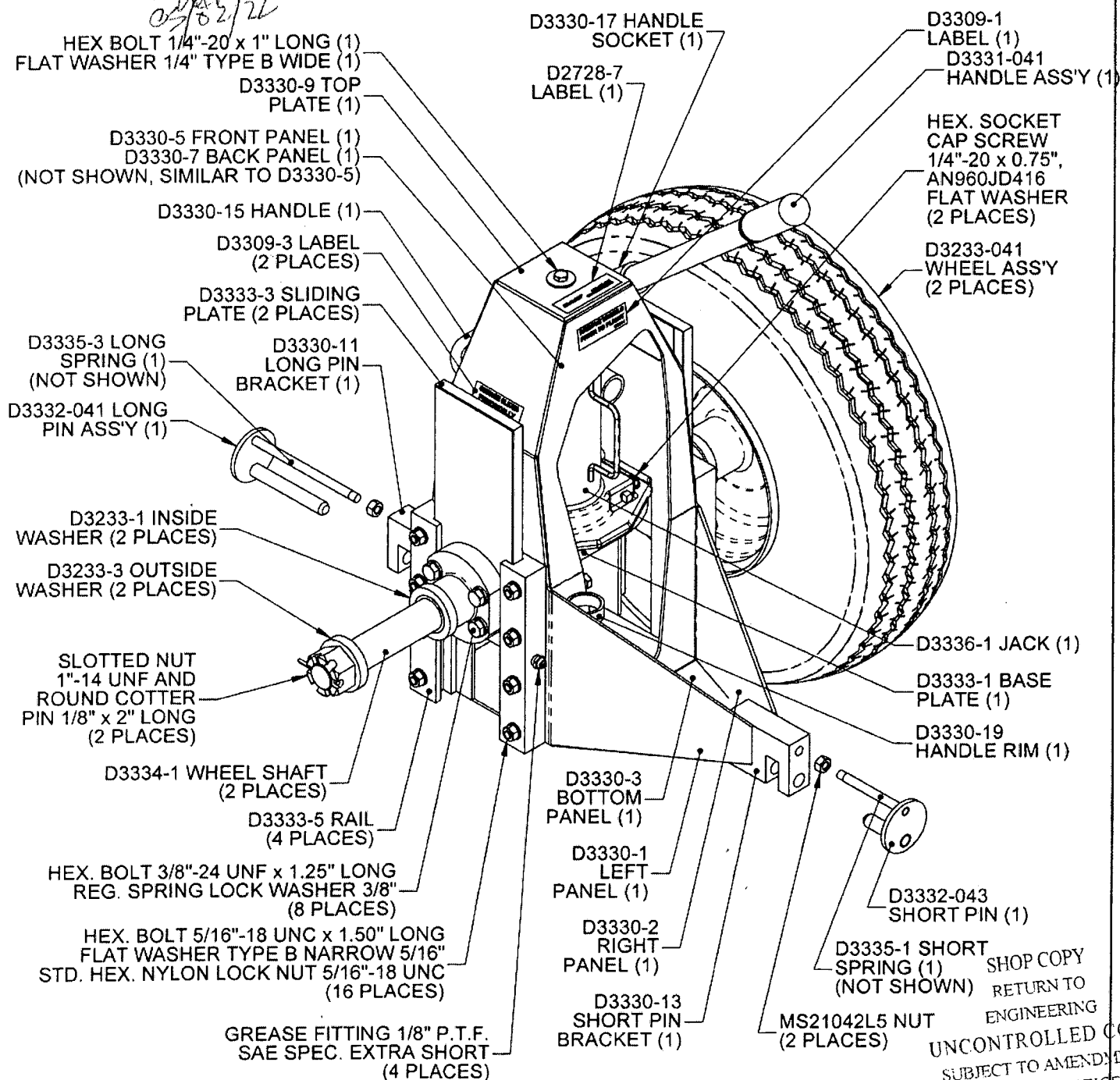
NOTE: Date & initial all entries



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED

05/02/18



NOTE:

- 1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE.
RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

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WORK ORDER
NO. 30948

Date: Friday, 2/23/2007 1:59:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW MEDIUM BELL
Job Number : 30948A	
Estimate Number : 12129	
P.O. Number : N/A	Part Number : D412729041
This Issue : 2/23/2007 S.O. No. : N/A	Drawing Number : DSK 092 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30947A	Material : N/A
Written By : _____	Due Date : 3/30/2007 Qty: 2 Um: Each
Checked & Approved By : <u>07.02.26</u>	
Comment : Est Rev: 05.04.13 LPS3 rust inhibitor added; Hardware P/N's changed KJ/JLM	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

If D412-729-041 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-729-041 CHG003

2.0

D27287

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2728-7 Label 322554

07.03.23

3.0

D3233041

Wheel Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-041 Wheel Assembly 328609

07.03.23

4.0

D32331

Inside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3233-1 Inside Washer 328610

07.03.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D32333

Outside Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3233-3 Outside Washer B2861-1

P/L 07-03-23

6.0

D33091

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3309-1 Label B23767

P/L 07-03-23

7.0

D33093

Label



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3309-3 Label B23768

P/L 07-03-23

8.0

D3330041

Frame Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3330-041 Frame Weldment B30950

P/L 07-03-23

9.0

D3331041

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3331-041 Handle Assembly B23769B

P/L 07-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D3332041

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-041 Long Pin Assembly B23770

PL 07-03-23

11.0

D3332043

Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3332-043 Short Pin Assembly B23771

PL 07-03-23

12.0

D33331

Base Plate Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-1 Base Plate B28615

PL 07-03-23

13.0

D33333

Sliding Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3333-3 Sliding Plate B30951

PL 07-03-23

14.0

D33335

Rail



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3333-5 Rail B30952

PL 07-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D33341

Wheel Shaft



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3334-1 Wheel Shaft B30953

PK 07-03-23

16.0

D33351

Short Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-1 Short Spring B22256

PK 07-03-23

17.0

D33353

Long Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3335-3 Long Spring B22256

PK 07-03-23

18.0

D33361

Jack



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3336-1 Jack B23772B

PK 07-03-23

19.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD416 Washer B10378

PK 07-03-23

20.0

CP21

1/8" Cotter Pin 2" long



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

PK 07-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 CP-21 1/8" Cotter Pin 2" long, Span M16626

21.0

HC12

1/4-20 UNC x 1" Hex Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span M16529

Pl 07.03.23

22.0

HC29

5/16-18 UNCx1.5 Hex Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof M103717

Pl 07.03.23

23.0

HC153

3/8"-24UNFx1.25 Hex Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span M17356 → 2

M16626 → 14

Pl 07.03.23

24.0

HN120

HEX SLOTTED NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HN-120 1" Slotted Nut, Prof M103717

Pl 07.03.23

25.0

HN177

5/16-18UNC Nylon LockNut



Comment: Qty.: 16.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 HN-1775/16"-18 UNC Nylon Lock Nut, Span M16999

Pl 07.03.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

HX15

1/4-20 UNCx3/4 S.H.C.S.



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span M16626

P/L 07-03-23

27.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS21042L5 Nut (or -5) M102536

P/L 07-03-23

28.0

2333

1 1/4" Type B Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 2333 1 1/4" Type B Flat Washer (Wide), Span M102150

P/L 07-03-23

29.0

18SNB

3/8" Lock Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 18-SNB 3/8" Lock Washer, Span M19705

P/L 07-03-23

30.0

113803

1/8" PTF Grease Fitting



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 113-803 1/8" PTF Grease Fitting, Span M102771

P/L 07-03-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PP Date: 09/03/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: GHW MEDIUM BELL

Job Number: 30948A

Part Number: D412729041

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

516WC

SS Flat Washer 5/16



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 5/16"WC Type B Flat Washer (Narrow), Prof

~~D412729041~~

M103165

Pl 07-03-23

32.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



(2)

Pl 07-03-23

Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last.

33.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/26 (2)

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP

B 36948

07/13/28 (2)

35.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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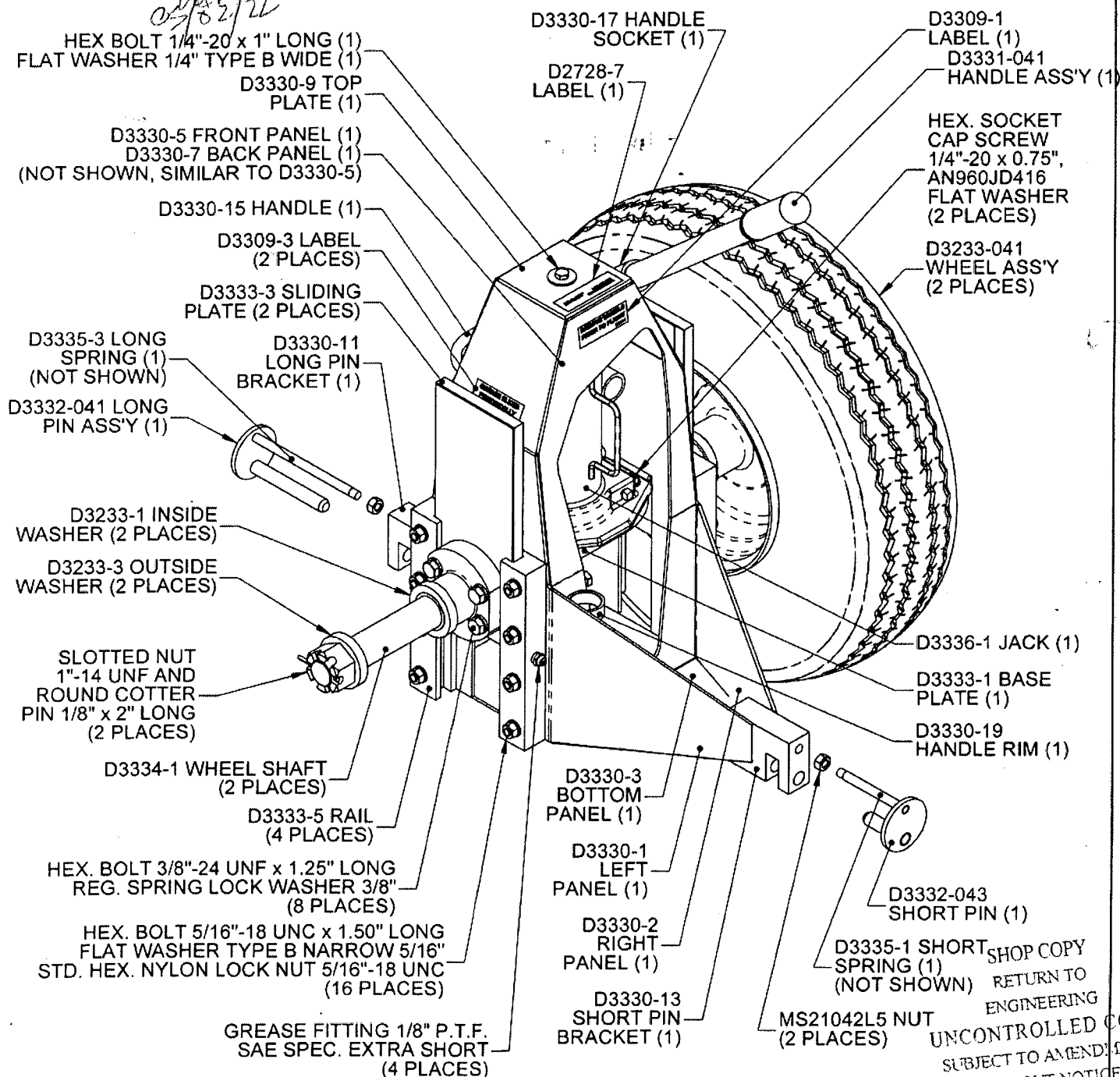
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CHECKED 	APPROVED 	DRAWING NO. DSK 092	REV. B SHEET 1 OF 1
DATE 05.02.18		TITLE HYD. GROUND HANDLING	SCALE 1:5
A	04.12.06	NEW ISSUE	
B	05.02.18	REDESIGN TO FIT NEW WHEEL ASS'Y	

RELEASED

05/02/18



NOTE:

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